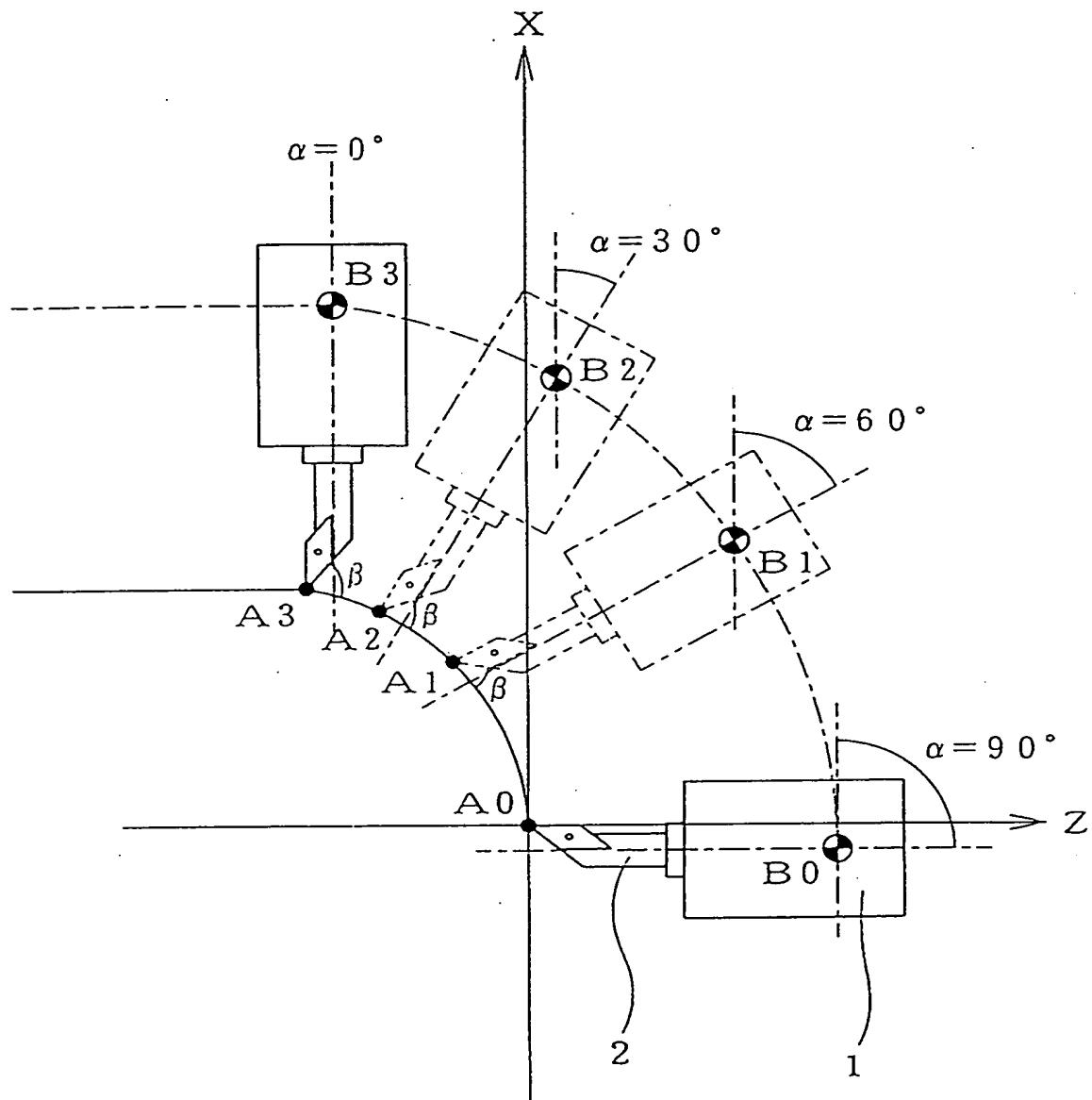
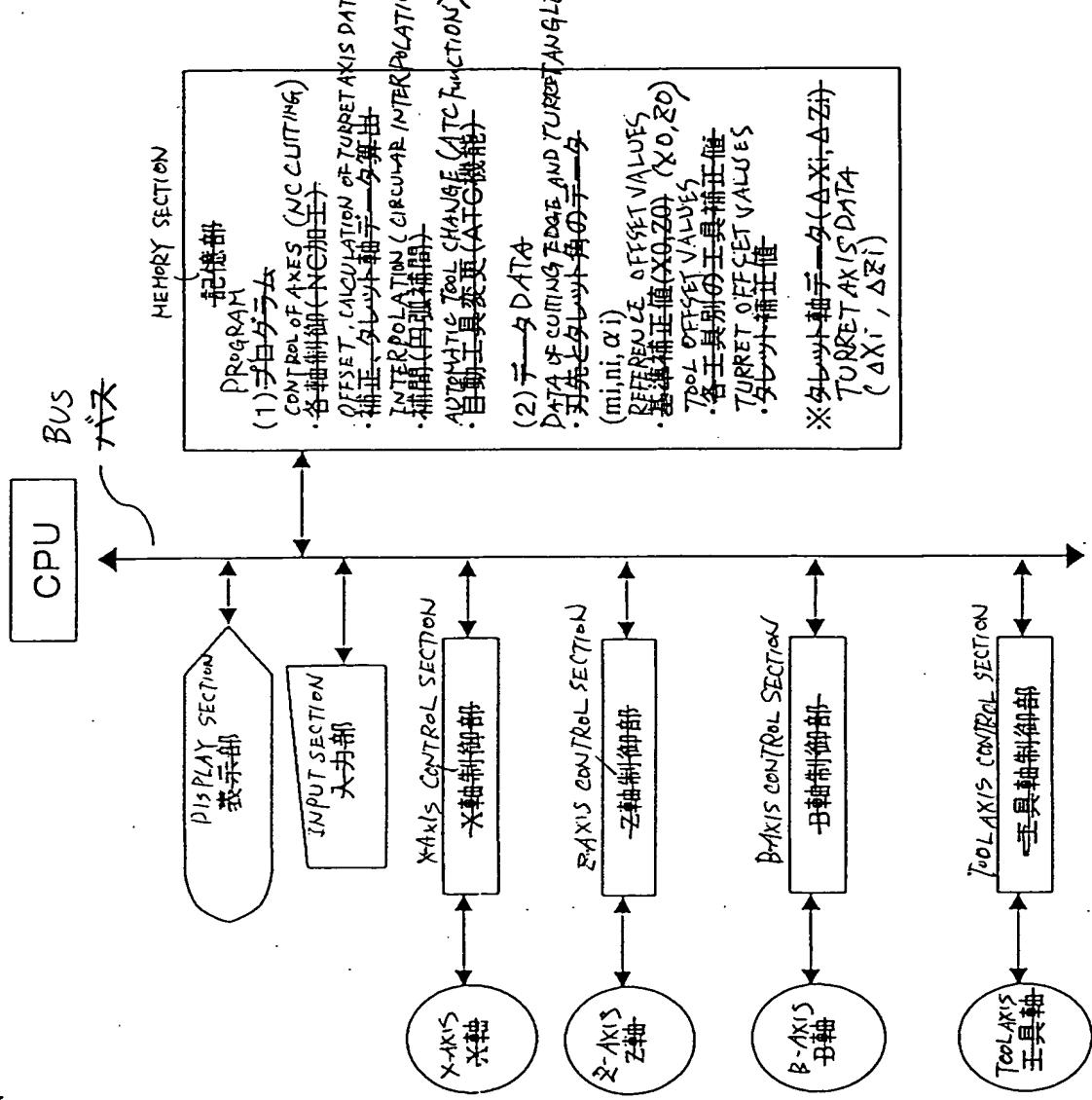


FIG. 1



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Fig. 2



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Fig. 3A

CUTTING EDGE POSITION	CUTTING EDGE DATA		TURRET EDGE DATA		TURRET ANGLE	
	mi	ni	ni	ai	Δxi	Δzi
A0	0	0	90°	90°	B0	-5
:	:	:	:	:	⋮	⋮
A1	20	-10	60°	60°	B1	35.7
:	:	:	:	:	⋮	⋮
A2	30	-20	30°	30°	B2	62.1
:	:	:	:	:	⋮	⋮
A3	35	-30	0°	0°	B3	75

Fig. 3B

TURRET AXIS POSITION	TURRET ANGLE	
	αi	αi
B0	-5	40
⋮	⋮	⋮
B1	35.7	27.1
⋮	⋮	⋮
B2	62.1	4.3
⋮	⋮	⋮
B3	75	-25
		0°

FIG. 4

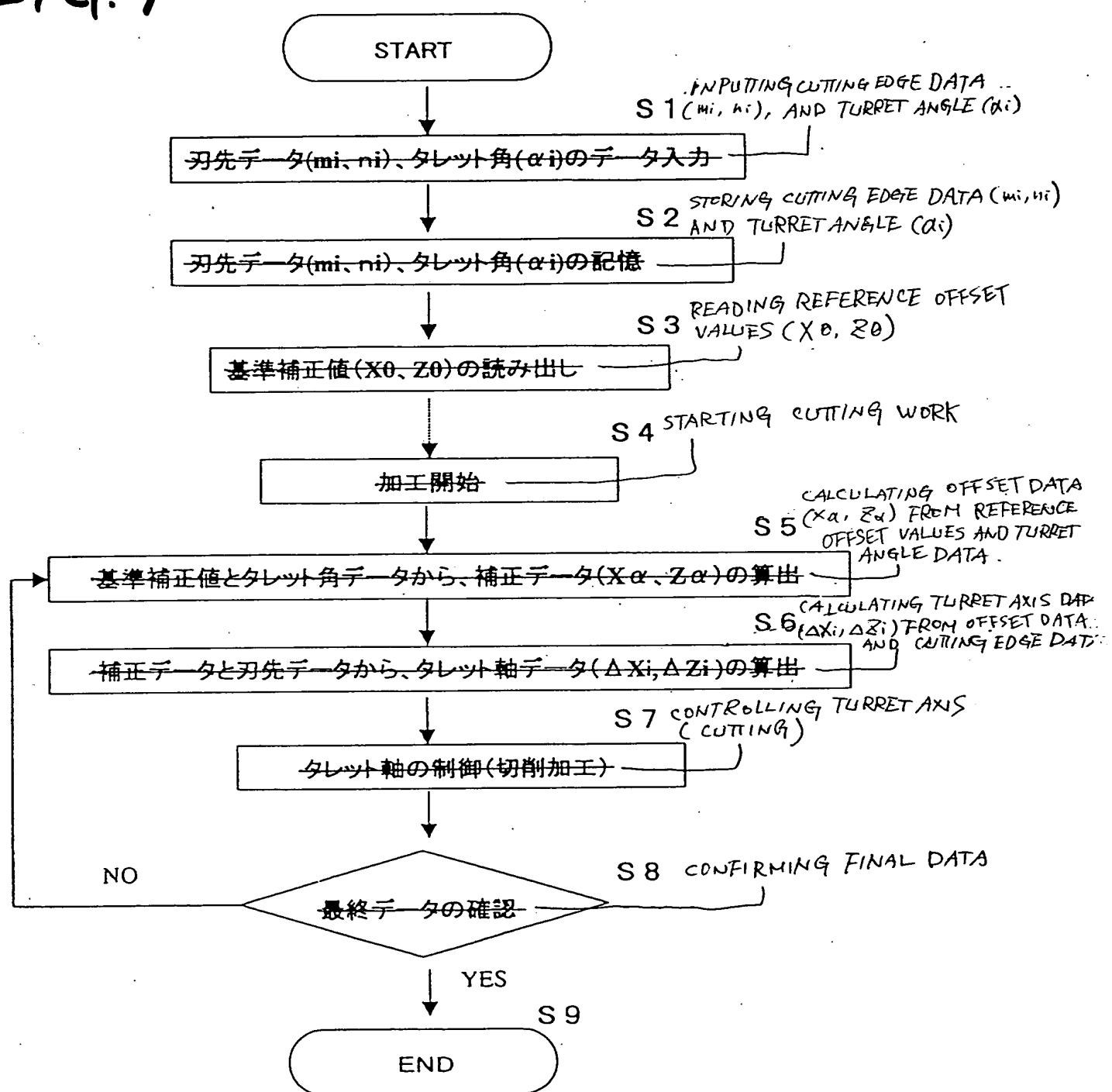


FIG. 5

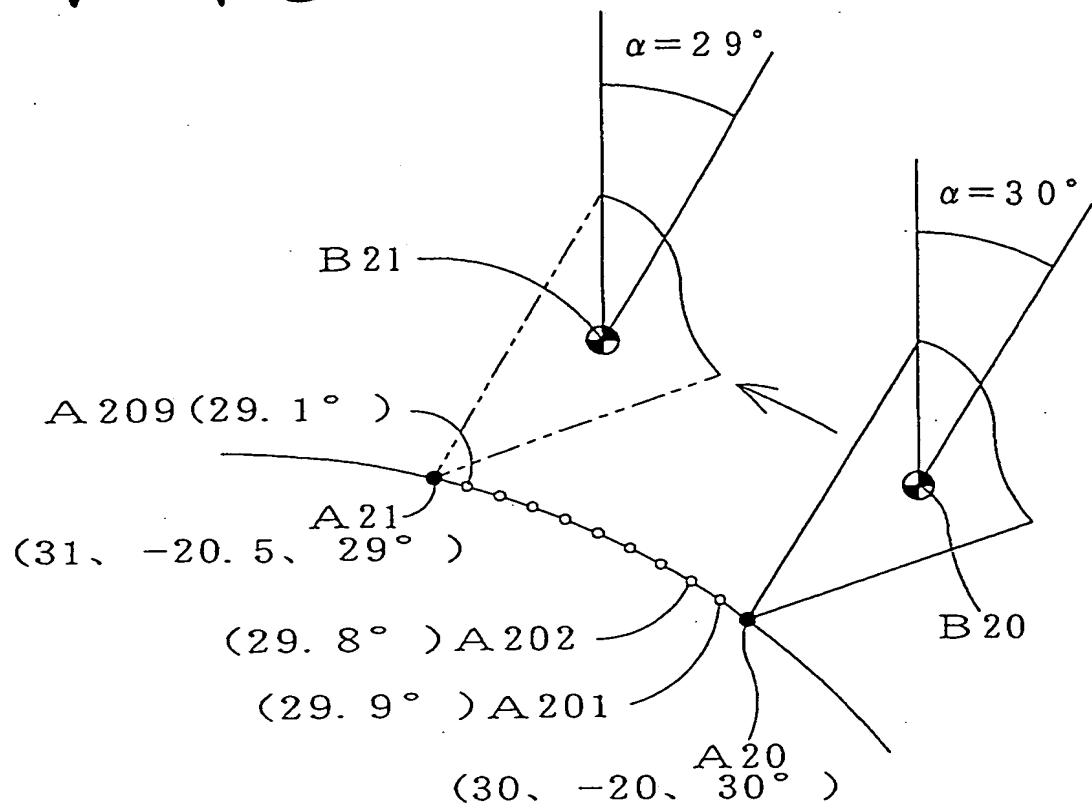


FIG. 6

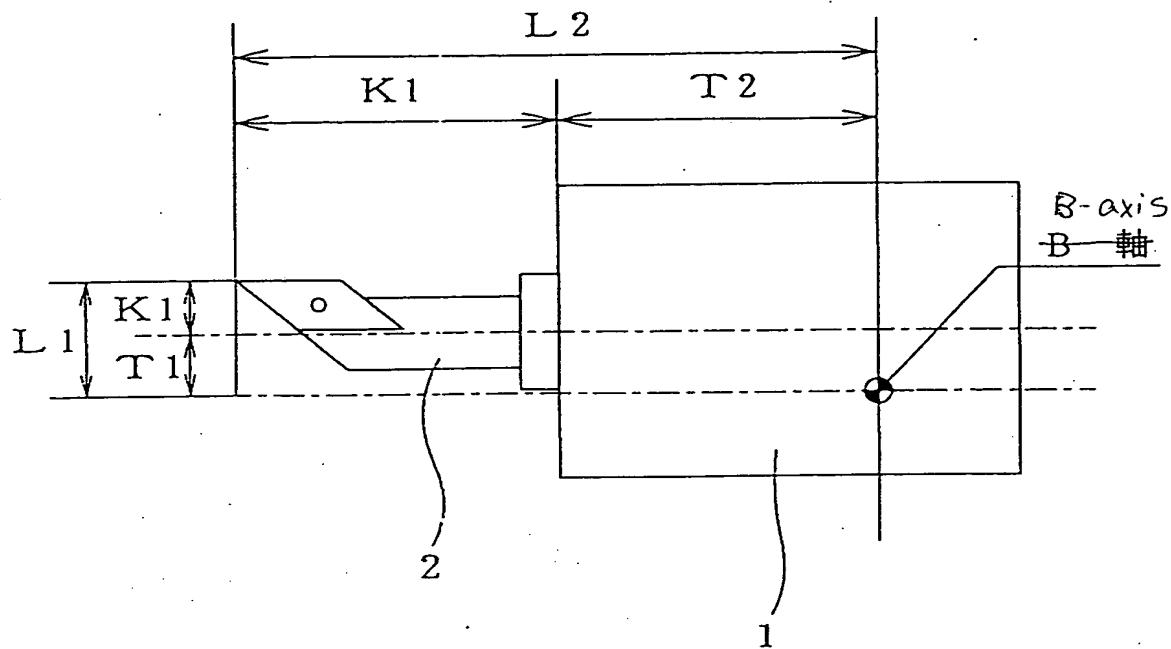


FIG. 7

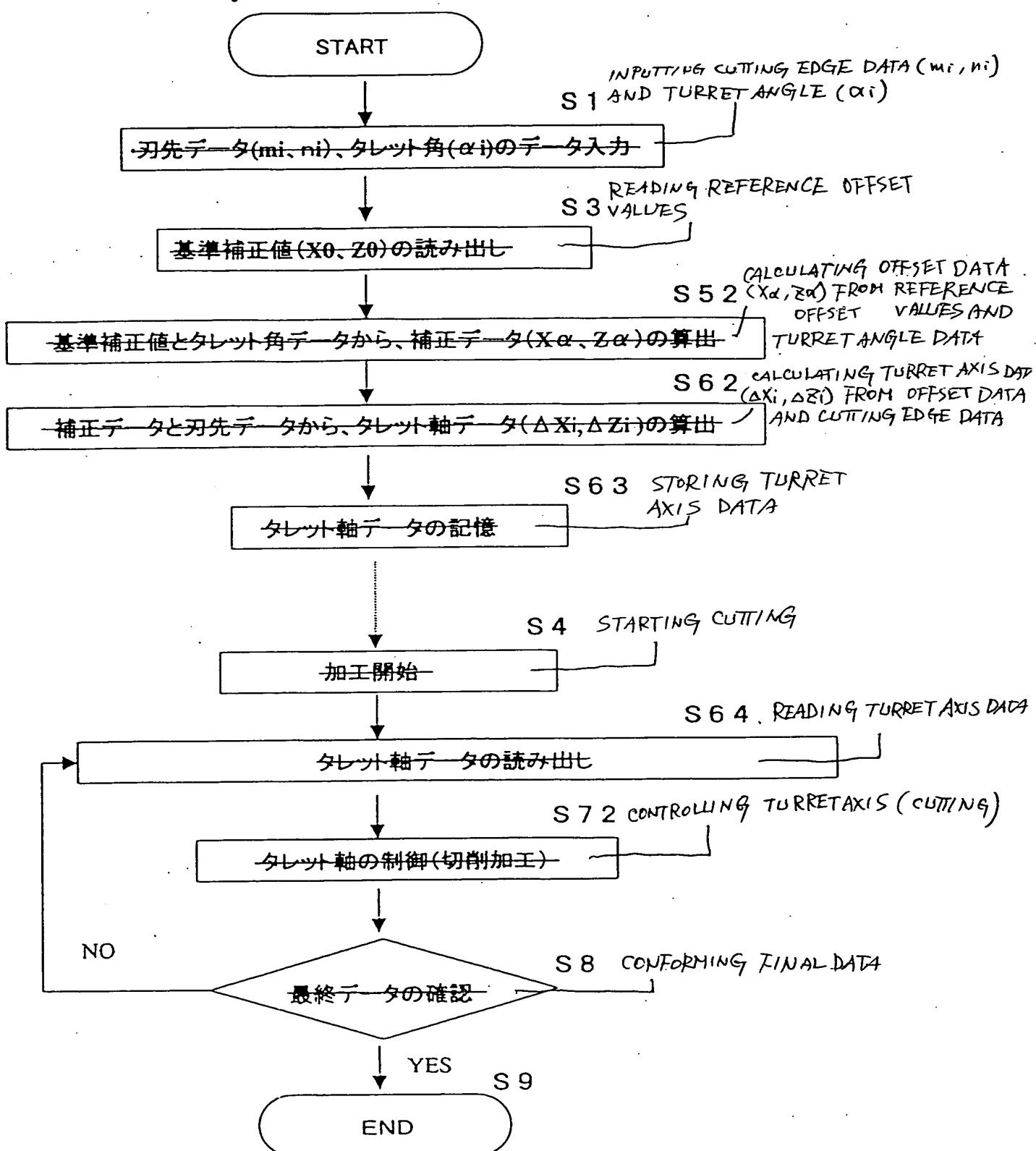
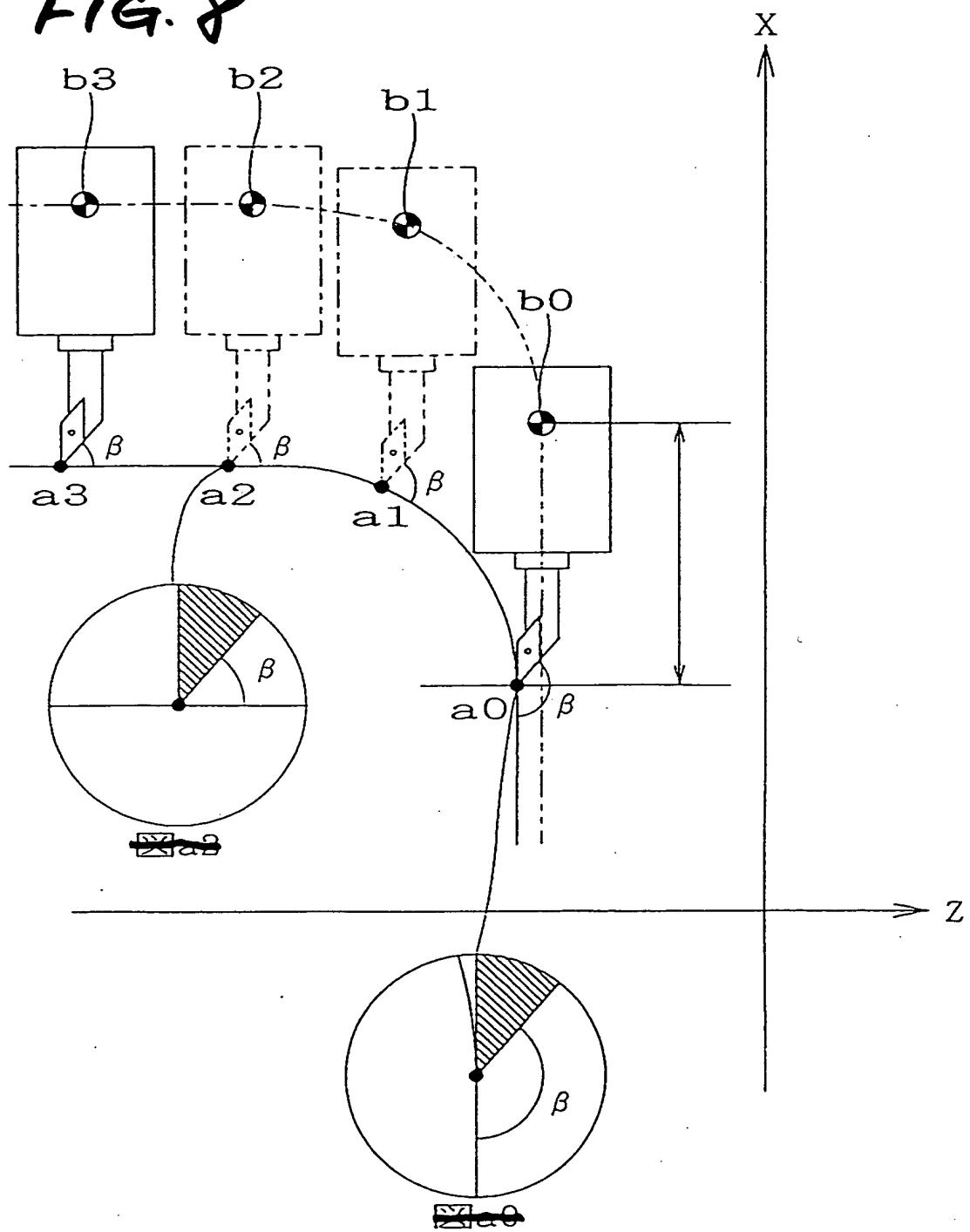
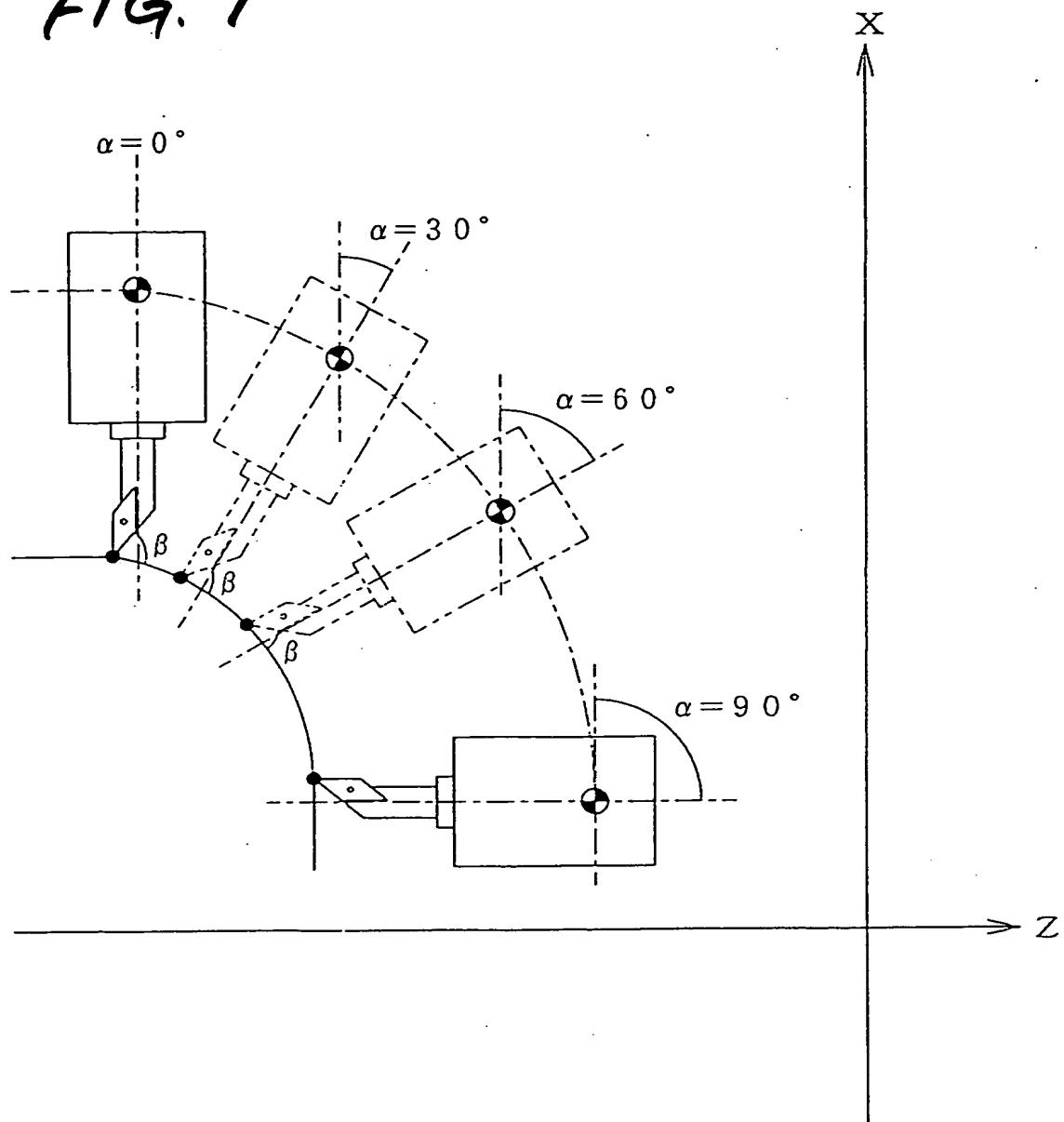


FIG. 8



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FIG. 9



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